

Date: Wednesday, 3/8/2006 10:38:11 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SHUT-OFF VALVE SHAFT
Job Number :	26115		
Estimate Number :	12170		
P.O. Number :	N/A	Part Number :	D34703
This Issue :	3/8/2006	Drawing Number :	D3470 REV.A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A	Drawing Revision :	A
Previous Run :	N/A	Material :	N/A
	Type :	Due Date :	3/31/2006
	PURCHASED PARTS	Qty:	10
Written By :	SEE COMMENT BELOW	Um:	Each
Checked & Approved By :	06.03.08		
Comment :	est rev A 06.02.03 new issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	OUTSIDE SERVICE	OUTSIDE SERVICES
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Comment: Sub-Contracting OUTSIDE SERVICES
 Issue P/O: 00000768 AB 06/03/09
 Email or Ship DXF file to vendor
 Laser Cut per Dwg D3470 flat pattern D3470-3F AB 06/03/09
 Material release note required

2.0	D34703F	ARM
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 ARM

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary.

SAD 06.03.29 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:38:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE SHAFT

Job Number: 26115

Part Number: D34703

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Dec 03 29 (12)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST439

C 206/03/29

(2)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/03/30 (2)

Job Completion



C Dec 03 29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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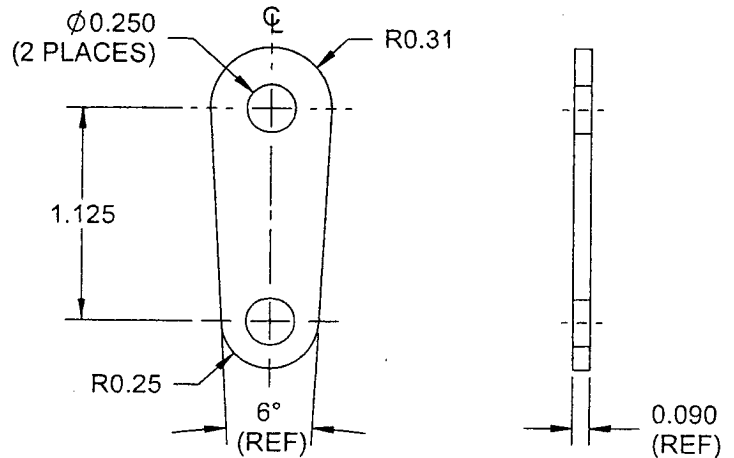
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3470	REV. A SHEET 3 OF 4
DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:1

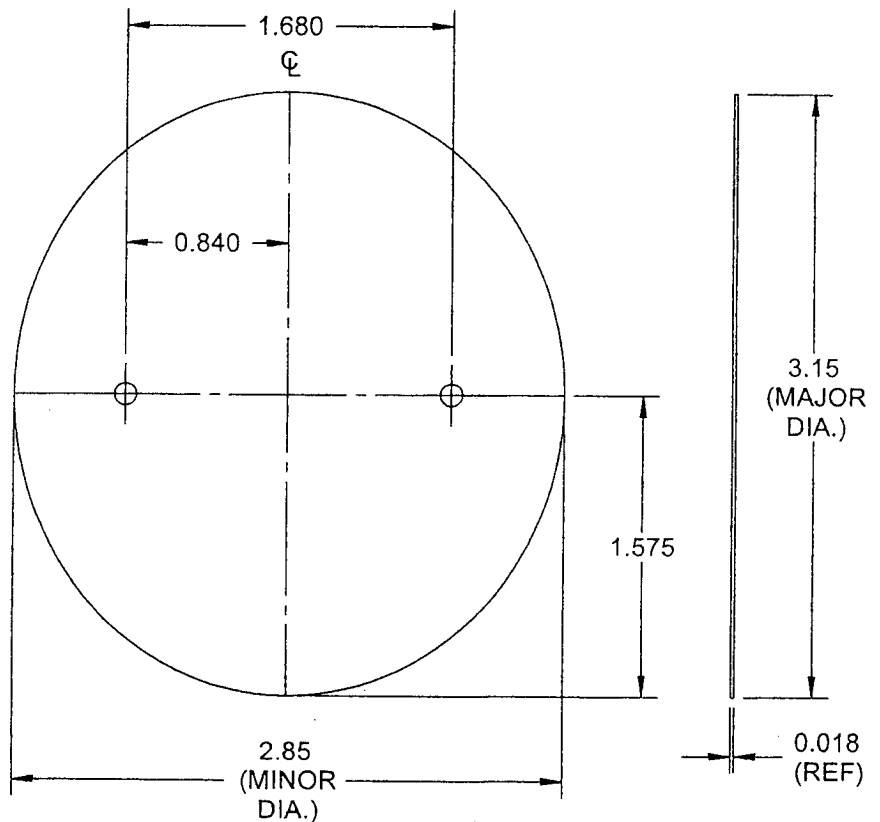
D3470-3 ARM

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 13 GAUGE SS (0.090 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE.



D3470-5 PLATE VALVE

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: ELECTRO CHEMICALLY POLISH.



NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

FAX 1 847 585 2500

CORUS ALUMINIUM

Corus Aluminium Walzprodukte G. m. b. H.
 100331 · D-56033 Koblenz



INSPECTION CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0879231 SERIAL-NO.: PAGE: 2 / 03
 PURCHASER: CORUS ALUMINIUM ROLLED ORDER NO. PURCH.: US-AIRCR. DEPOT-PRO
 PRODUCTS USA-A DIVIS ORDER NO. MAN.: 83415
 SCHAUMBURG, IL 60173 SPEC.: AMS4041+B209+QQ250/5
 CUSTOMER PART NO.:
 ITEM: 01 LOT: 102973 ALLOY/TEMPER: 2024 T3 ALCLAD 1230 PRODUCT: PLA
 QUANTITY: 344 DIMENSIONS: 0.040 x 48.00 x 144.00 INS

Other tests:

Dimensional check: OK
 Surface control: OK

Normative references:

BESTELLNORM/SPECIFICATION/NORME
 AMS 4041P+ASTM B 209-04+AMS-QQ-A-250/5A SEP1998

Bend test:

L-direction

LT-direction OK

ST-direction

18 G.
Koblenz



corus

CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE
PAGE: 3 / 03

SERIAL-NO.:
CORUS ALUMINIUM ROLLED
PRODUCTS USA-A DIVIS
CHAUMBURG, IL 60173
CUSTOMER PART NO.:
ORDER NO. PURCH.: US-AIRCR. DEPOT-PRO
ORDER NO. MAN.: 83415
SPEC.:
AMS4041+B209+Q0250/5

THAT THE WHOLE OF THE SUPPLIES DETAILED HEREON HAVE BEEN
TESTED AND, UNLESS OTHERWISE STATED ABOVE, CONFORM IN ALL
WITH THE REQUIREMENTS OF THE SPECIFICATION, CONTRACT OR ORDER.

res:

in 2, the 28.08.05 SW

G. Mettler
Quality Assurance
Corus Aluminium
Walzprodukte GmbH
Koblenz

FROM: MAR-23-2006 04:24

TO: 6049464153

CORUS ALUMINIUM

P/N 062310 POW3335

Corus-Aluminium-Walzprodukte G.m.b.H.
Postfach 100331 : D-58033 Koblentz

corus

INSPECTION CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0879231 SERIAL-NO.: ORDER NO. PURCH.: US-AIRCR.DEFOT-PRO
 PURCHASER: CORUS ALUMINIUM ROLLED ORDER NO. MAN.: 83419
 PRODUCTS USA-A DIVIS SPEC.: AMS4041+B209+GQ2S0/5
 SCHAUMBURG, IL 60173 CUSTOMER PART NO.:
 ITEM: 01 LOT# 102973 ALLOY/TEMPER: 2024 T3 ALCLAD 1230 PRODUCT: PLA
 QUANTITY: 344 DIMENSIONS: 0.040 X 48.00 X 144.00 INS

PAGE: 1 / 03

RESULTS:

Mechanical properties:

	Spec: No.	Y.S.	U.T.S.	El.
		KSI	KSI	%
Min. LT:	39,0	59,0	59,0	15,0
Max. LT:				
001	40,6	59,6	59,6	17,9
002	40,6	59,8	59,8	18,7
003	40,8	59,8	59,8	17,7
004	40,8	59,6	59,6	18,1

Chemical composition: in %, remainder Al

ALLOY: CAST-NO.	ALLOY CORE	ALLOY LINER	ALLOY LINER
Si	2024	1230 4	1230 4
Fe	5-05-2914	142166-1	142166-1
Cu	0,028	0,12	0,12
Mn	0,123	0,26	0,26
Mg	4,525	0,002	0,002
Cr	0,634	0,010	0,010
Zn	1,436	0,003	0,003
Ti	0,100	0,001	0,001
B	0,110	0,005	0,005
Zr	0,0278	0,019	0,019
Pb	0,000	0,002	0,002
IN	0,000	0,001	0,001